

Date: Tuesday, 03/02/2009 2:34:48 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE KIT
Job Number : 45468
Estimate Number : 13776
P.O. Number :
This Issue : 03/02/2009 S.O. No. :
Prsht Rev. : NC Part Number : D119647021
First Issue : / / Type : LARGE FAB ASSY Drawing Number : DSI 9432 REV.A
Previous Run : Project Number : N/A
Drawing Revision : A
Material :
Due Date : 23/02/2009 Qty: 2 Um: Each
Written By :
Checked & Approved By : JLD 09-02-03
Comment : Est Rev:A 09-02-03 new issue DD verified by:JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D119-647-021 and DSI9432 CHG 001

2.0 D3861041 Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Wearplate

batch: B45476

3.0 AN415A Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

batch: M1K9148

4.0 NAS1149D0463J Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

batch: M110523

5.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

batch: M109282

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

205-08-01 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-647-021 and DSI9432

Location: _____

PPP Rev: _____

Draft

8809/05/01 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-647 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-647 REV. 0

REF. FAA STC: SR00949SE
REF. AUSTRIAN STC: ACG.21NE.012
REF. ITALIAN STC: N-CS-022

The D119-647-021 Wearplate kit can be installed on D119-647-011 Bearpaw installations. The D3861-041 Wearplates should be installed on the D3034-1 Bearpaws as shown in Figure 1 on Sheet 2 of this Service Instruction. The Bearpaws should otherwise be installed on the skidtube per installation instructions IIN-D119-647 Rev A.

Customers with old style bearpaws will need to rework the counterbore on the bottom of the bearpaws per Figure 1 of Sheet 2 of this service instruction.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D119-647-021 Wearplate Kit	3.46 lb 1.57 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	173.2 in 4.40 m	599.3 in-lb 6.91 m-kg

PARTS LIST

QTY. -021	PART NUMBER	DESCRIPTION
X	D119-647-021	Wearplate Kit
2	D3861-041	Wearplate
12	AN4-15A	Bolt
12	NAS1149D0463J	Washer
12	MS21042L4	Nut or (MS21042-4)

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WITHOUT NOTICE
WORK ORDER
NO. H54108

A	NEW ISSUE	BY	09.01.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN			
CHECKED	DRAWING NO.		REV. A
MFG. APPR.	DSI 9432		SHEET 1 OF 2
APPROVED	TITLE		SCALE
DE APPR.	WEARPLATE KIT		NTS
DATE	09.01.15	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

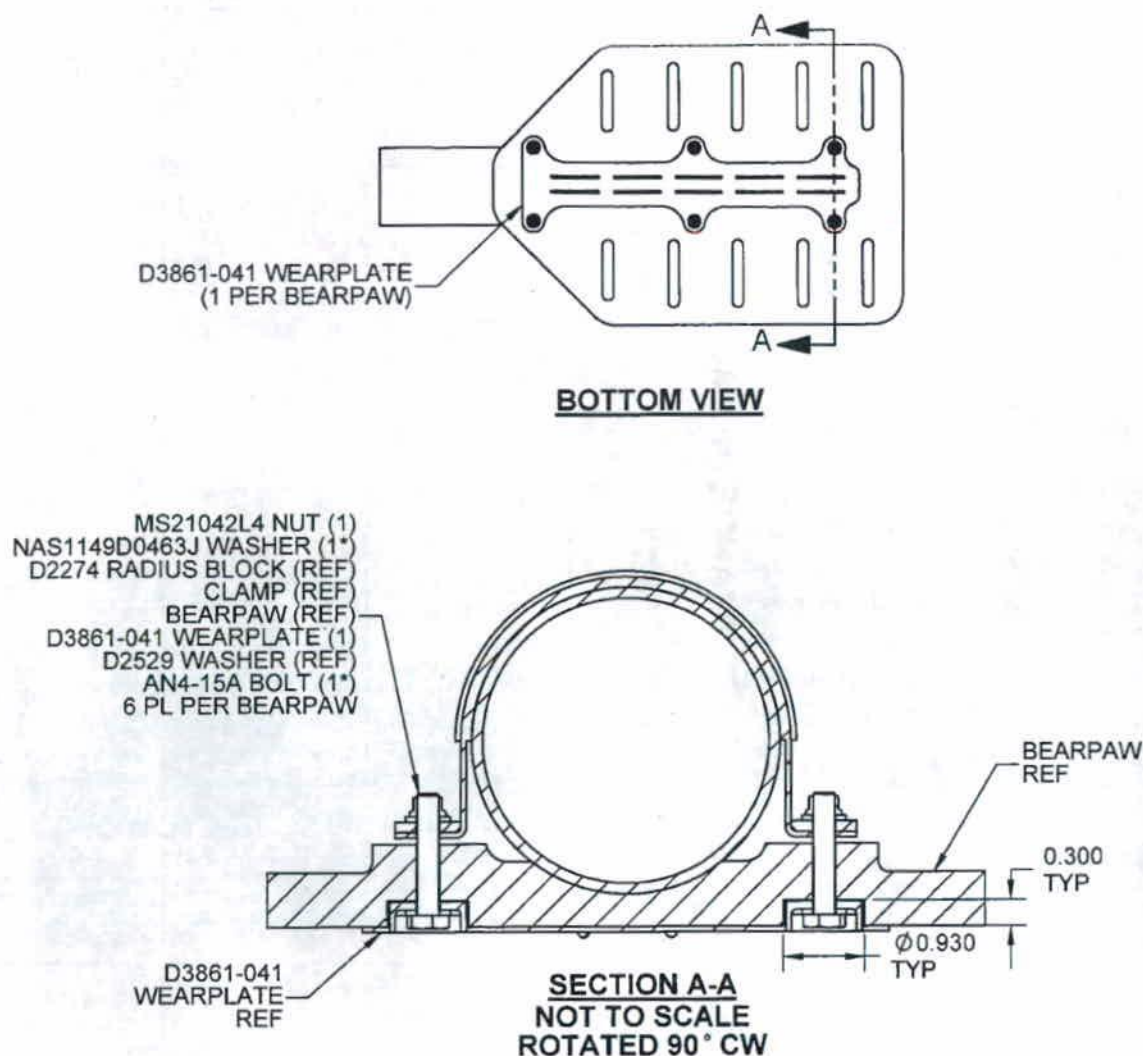
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* ADDITIONAL NAS1149D0463J WASHERS MAY BE INSTALLED UNDER NUTS TO ENSURE 1.5 - 4 THREADS IN SAFETY ON BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4-15A BOLTS WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

FIGURE 1: D119-647-021 WEARPLATE KIT

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45468

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9432	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE KIT	NTS
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